

# Work Order ID 78739

\*78739\*

Page 1

January-13-12 9:55:23 AM

Item ID: D3138-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover  
 Start Date: 13/01/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 27/01/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: H.L.J Date: 12/01/13 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3138	Rev C

100	FLOW WATER JET	0.00							
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\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3138

7024 .037

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control



12/01/13

12

2 0 JM 12-8-18

2 0 JM 12-8-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*78739\***

January-13-12 9:55:23 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 13/01/2012    **Start Qty:** 2.00    **\*2\***

**Required Date:** 27/01/2012      **Req'd Qty:** 2.00      **\*~\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*130\***

## Small Fab

0.00

### Small Fab

## Memo

## Small Fab

Deburr

Bend as per Dwg D3138

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

0.00

QC

## Memo

## Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

0.00

HandFinish

## Memo

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 78739

\*78739\*

Page 3

January-13-12 9:55:23 AM

Item ID: D3138-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Cover

Start Date: 13/01/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*160\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00

3200F

9:30

2X ✓

MZ 12/08/24

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

2x ✓ 12/08/24

180

Identify as per dwg & Stock Location

0.00

\*180\*

Packaging

Memo

0.00

Packaging

2X ✓ 12/8/27

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 78739****\*78739\***

Page 4

January-13-12 9:55:23 AM

Item ID: D3138-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Cover  
Start Date: 13/01/2012      Start Qty: 2.00      **\*2\***      Cust Item ID:  
Required Date: 27/01/2012      Req'd Qty: 2.00      **\*2\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

CK 12/8/28

MR  
12-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January-13-12 9:55:27 AM

Page 1

Work Order ID: 78739

**\*78739\***

Parent Item: D3138-1

**\*D3138-1\***

Parent Item Name: Cover

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

**Comments:**

IPP Rev: B 04.11.29Made by Laser CutKJ/RF  
 IPP Rev: C 05.12.13added level 5 EC  
 IPP rev:D 08-05-12 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

110

sf

106.7000

1.8427

~~3.879368~~

**\*\***

**3.9**

**\*M2024T3S 032\***

2024-T3 .032 sheet

Jun 12-8-18

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

**121309**

**121307**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	78739
<b>Description:</b> Cover		<b>Part Number:</b>	D3138-1
<b>Inspection Dwg:</b> D3138 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.603	+/-0.010	0.598"	✓		✓	mmoi
0.203	+/-0.010	0.199"	✓		✓	
1.82	+/-0.030	1.832"	✓		✓	
2.27	+/-0.030	2.293"	✓		✓	
2.49	+/-0.030	2.488"	✓		✓	
3.44	+/-0.030	3.436"	✓		✓	
1.42	+/-0.030	1.431"	✓		✓	
6.23	+/-0.030	6.230"	✓		✓	
12.46	+/-0.030	12.46"	✓		T	
18.47	+/-0.030	18.47"	✓		T	
24.52	+/-0.030	24.52"	✓		T	
30.76	+/-0.030	30.76"	✓		T	
37.00	+/-0.030	37.00"	✓		T	
43.13	+/-0.030	43.13"	✓		T	
49.20	+/-0.030	49.20"	✓		T	
55.26	+/-0.030	55.26"	✓		T	
61.10	+/-0.030	61.10"	✓		T	
67.23	+/-0.030	67.23"	✓		T	
72.33	+/-0.030	72.33"	✓		T	
77.14	+/-0.030	77.14"	✓		T	

<b>Measured by:</b>	Jm	<b>Audited by:</b>	DAS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12-8-18	<b>Date:</b>	16 12/8/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.23	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

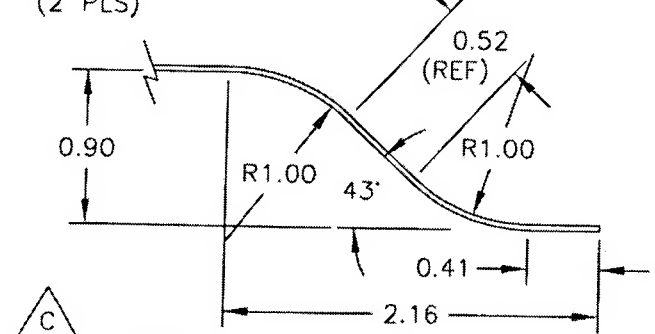
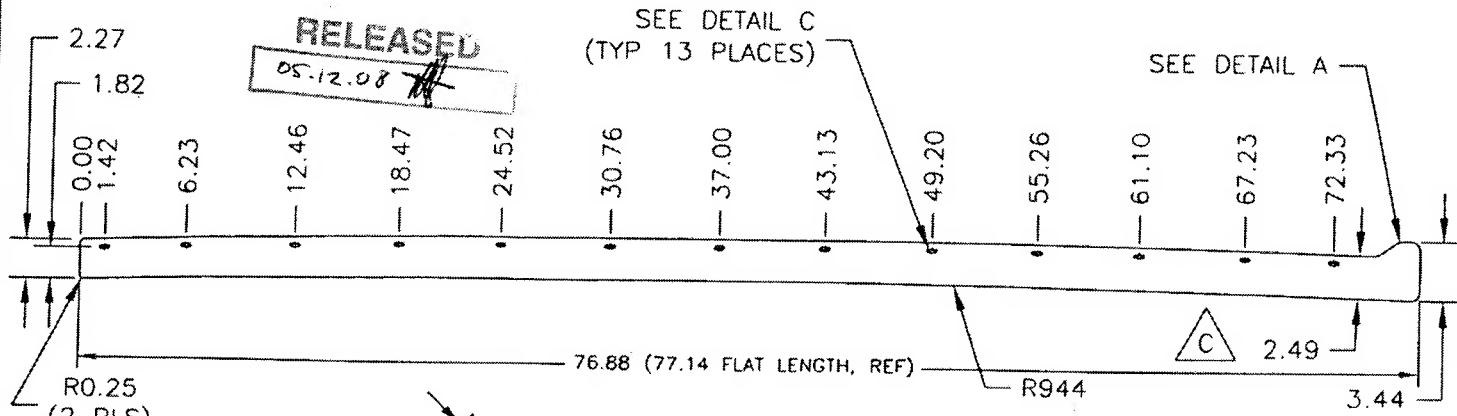
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**DART**

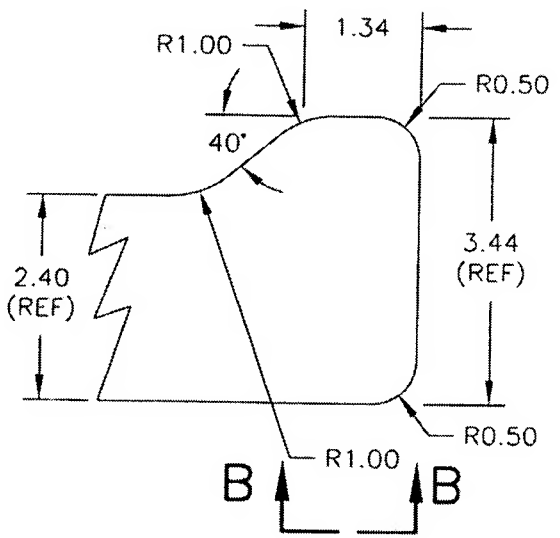
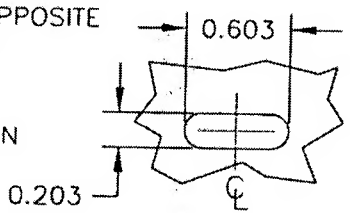
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	CP	DRAWN BY	RF	DRAWING NO.	REV. C
CHECKED		APPROVED		D3138	SHEET 1 OF 1
DATE	05.12.05	TITLE	COVER	SCALE	1:10
A	02.04.18	NEW ISSUE			
B	04.09.20	RE-DESIGN			
C	05.12.05	CORRECT VIEW B-B; ADD 2.49 DIM.			



**VIEW B-B**  
BEND D3138-1 AS SHOWN  
BEND D3138-2 OPPOSITE  
SCALE 1:1

**DETAIL C**  
LOCATION DIMENSION  
TO CENTERLINE  
SCALE 1:1



**DETAIL A**  
FLAT PATTERN SHOWN  
SCALE 1:2

**D3138-1 COVER (SHOWN. REPLACES PREMIER P/N B30-23000-205)**  
**D3138-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-206)**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S:032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

UNCONTROLLED COPY  
SUBJECT TO REVISION  
WITHIN 1000 HOURS  
WD 00000000

NO. 70739 H.C.J.  
12/01/13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries